

Work Order ID 62415

Wednesday, September 29, 2010 2:21:39 PM



Page 1

Item ID: D3774-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Back, LH/RH

Start Date: 9/29/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 10/7/2010 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: WF Date: 10-9-29 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3774	Rev B								

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Set up machine program D3774-3 □ Set up clamping frame as per folio

BB
10/10/05

110

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

X5 BB
10/10/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Item Name:	Seat Back, LH/RH					
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Required Date:	10/7/2010	Req'd Qty:	5.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115 	Dry Material	0.00							
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								
	Temp: <u>240°F</u>								
	Time IN: <u>4:30 PM 10/10/05</u>								
	Time OUT: <u>7:00 AM 10/10/05</u>								
120 	THERMOFORMING MACHINE	0.00							
Thermoform	Memo	0.00							
Thermoforming Machine	Thermoform as per Dwg. D32811 and Folio FTA 011 <input type="checkbox"/> Dwg. Rev.								
	<u>B</u> <input type="checkbox"/> Folio Rev. <u>C</u>								
130 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QD	Memo	0.00							
Quality Control									

BB
10/10/05

(XS) BB 10/10/05

(XS) BB 10/10/05

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions	0.00 0.00							
150  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo 1) Check dimensions to ensure conformity to drawing tolerances.	0.00 0.00							
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

Wk (X5) 10/10/5

OK (X5) 10/10/5

(X5)

8/10/10/07

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 257

0.00



Packaging

Memo

0.00

Packaging

10/10/07 [Signature]

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/08 [Signature]

MF

10-10-07

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 62415



Parent Item: D3774-3



Parent Item Name: Seat Back, LH/RH

Start Date: 9/29/2010

Required Date: 10/7/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A New Issue 08.06.04 DL verified by:DD
IPP REV. B Dwg. Update 08.08.19 DL
Add Step 115 Dry Material 10/04/21 DL

Ipp Rev. C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	2,185.803	10.667	53.335			

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT

2185.8038

114032

184.9238

115261

2000.88

XS

Bridgely

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 62415
Description: Seat Back		Part Number: D3774-3
Inspection Dwg: D3774	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

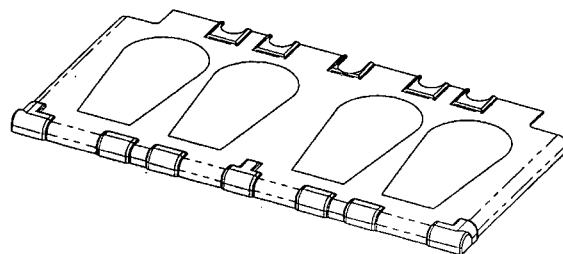
Measured by: 10/10/05 Date: 10/10/05

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.315	✓			
33.9	+/-0.100	33.875	✓			
0.085	Min	0.088	✓			
0.100	Min	.100	✓			
0.100	Min	.103	✓			
0.100	Min	.115	✓			
0.100	Min	.118	✓			
0.100	Min	.116	✓			
0.100	Min	.105	✓			
0.100	Min	.102	✓			
0.100	Min	.102	✓			

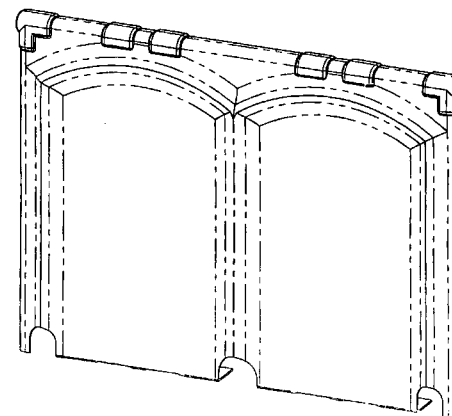
Measured by: 10/10/05 Date: 10/10/05
 Audited by: JB Date: 10/10/05
 Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	
B	09.05.19	Dimension 17.4 removed	KJ	



D3774-1 SEAT BOTTOM

62415



D3774-3 SEAT BACK

RELEASED
08-08-11/11

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3); REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO.	REV. B
CHECKED	PH	D3774	SHEET 1 OF 3
MFG. APPR.	PH	TITLE	SCALE
APPROVED	PH	SEAT	NTS
DE APPR.	PH	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.07.25		

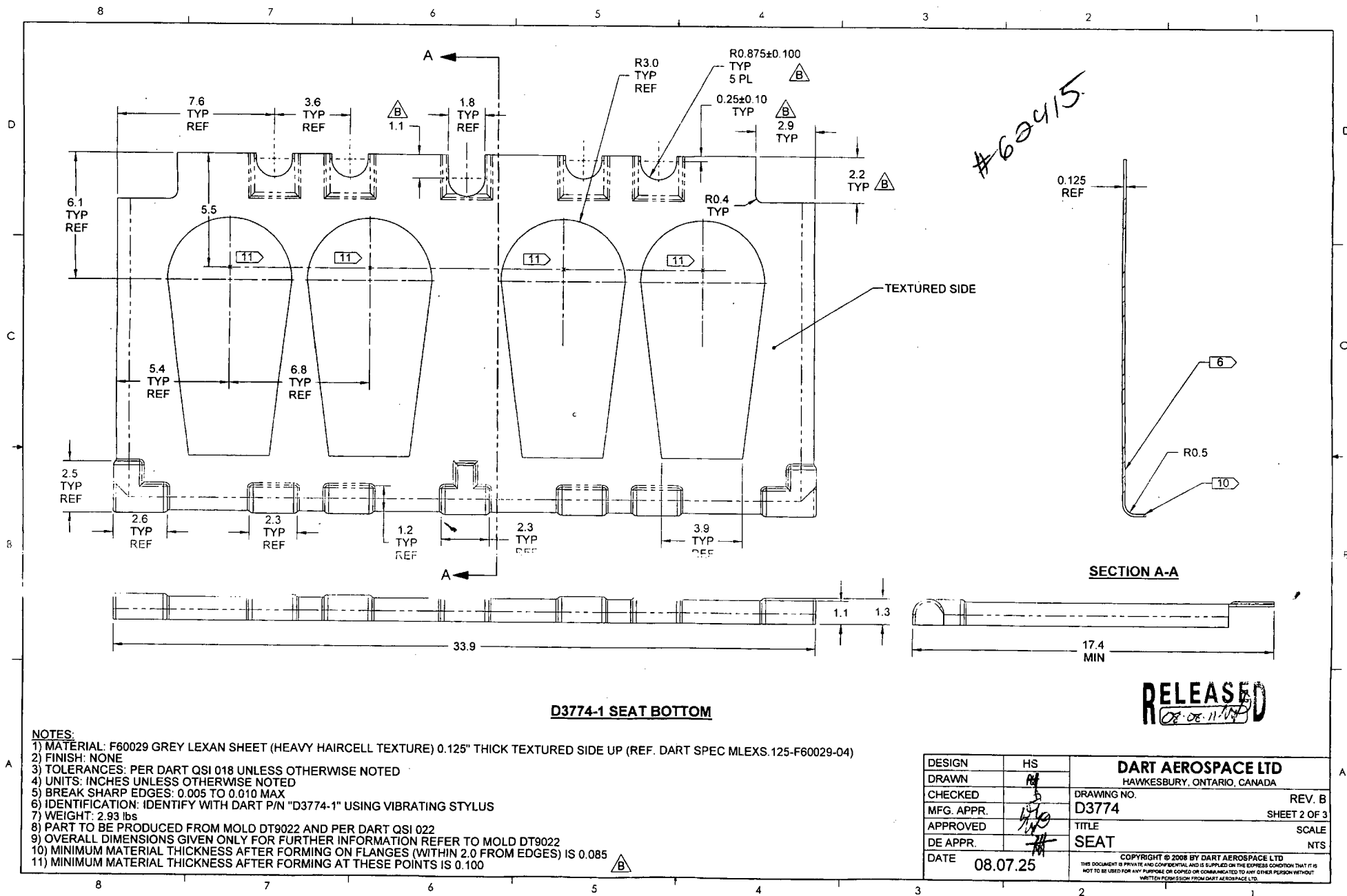
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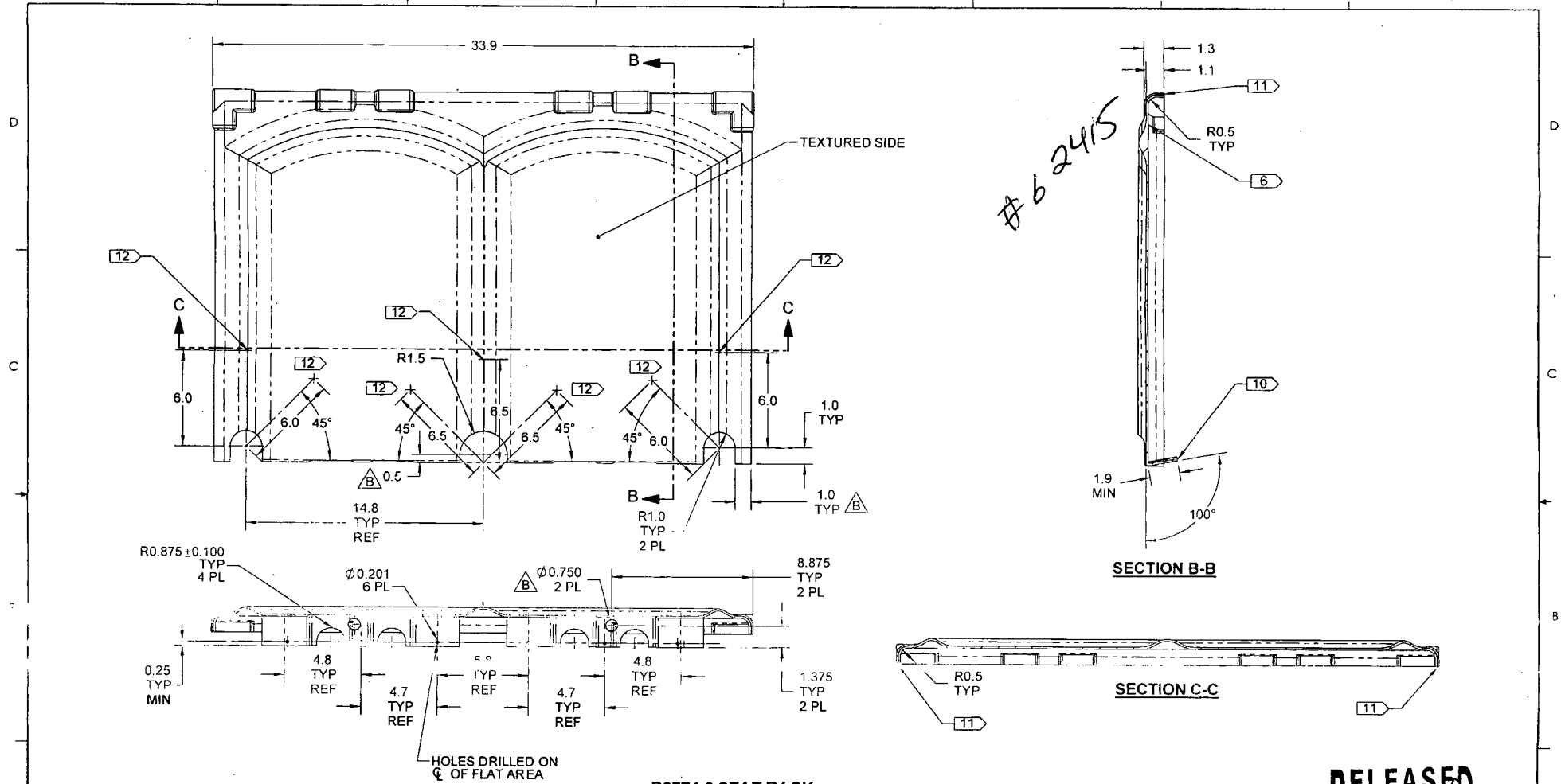
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8 7 6 5 4 3 2 1



D3774-3 SEAT BACK

- NOTES:**
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
 - 7) WEIGHT: 4.82 lbs
 - 8) PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022
 - 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023
 - 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.065
 - 11) MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
 - 12) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

RELEASED
08-05-11

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	Ad		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3774	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT	NTS
DATE	08.07.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1